

Work Order ID 53150

October 23, 2009 9:57:59 AM



Page 1

Item ID: D350-591-311

Accept



Setup Start



Revision ID: B

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 23/10/2009 Start Qty: 5.00



Test Item ID:

Required Date: 18/11/2009 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan: *R/*

Date: *04/10-23*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

Sort 10/17

HJ for BG 09/11/17

110

0.00



Large Fab

Large Fab

Memo

0.00

1-Bevel end for welding FWD ONLY

lh

09.11.09

5

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

lh

A/R Aluminum Rod

1111311
1111494

3-Grind End Plate flush

lh

Work Order ID 53150

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Item ID: D350-591-311

Accept



Setup Start



Revision ID: B

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 23/10/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

5

0

ZE 09/11/09

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5

09.11.10

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

5

0

09.11.10

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Item ID: D350-591-311

Accept



Setup Start



Revision ID: B

Item Name: Heli-Access-Step, Long LH

Stop



Start Date: 23/10/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 18/11/2009 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

SAI

09-11-10

Quality Control

5

180

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod 1111311

6-Grind End Plate flush

7-Install last rivet as per Dwg

09-11-11

5

0

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Item ID: D350-591-311

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Setup Start



Revision ID: B

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 23/10/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 18/11/2009 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

190

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PD 09.11.11 (5)

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5 09.11.12

210

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

M 09/11/12

(X5) 0

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October 23, 2009 9:57:59 AM

Item ID: D350-591-311

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Setup Start



Revision ID: B

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 23/10/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 18/11/2009 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M112148 Memo START TIME: 2:00 PM OVEN TEMPERATURE: 320°F FINISH TIME: 2:30 PM	0.00 0.00	⇒ M1 09/11/12			(X5)	✓		
230 HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch M112623 Memo	0.00 0.00	M1009/11/16			X5			
240 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	1/11/17			(5)			



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Item ID: D350-591-311

Accept



Setup Start



Revision ID: B

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 23/10/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 18/11/2009 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

9/11/17

52 2/3

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

27 S 09/11/12

540 4

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-311

Location: _____

NEV B

1/19/14/18 (5)

Work Order ID 53150

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October 23, 2009 9:57:59 AM

Item ID: D350-591-311

Accept



Setup Start



Revision ID: B

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 23/10/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 18/11/2009 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/19

Picklist Print

October 23, 2009 9:58:03 AM

Page 1

Work Order ID: 53150

Parent Item: D350-591-311RevB

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 23/10/2009

Required Date: 18/11/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3065-041RevB Manufactured No

Each 62.0000 5.0000



Step Leg Assembly Hi

12 09.11.11

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 22

51125 22

Main Warehouse

WA 40

52104 40

D3066-1RevB Manufactured No

Each 74.0000 10.0000



Spacer

12 09.11.11

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 74

51545 74

D3219-1RevA Manufactured No

Each 128.0000 10.0000



Plate

12 09.11.09

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 128

52230 128

10

Picklist Print

October 23, 2009 9:58:03 AM

Work Order ID: 53150

Parent Item: D350-591-311RevB

Parent Item Name: Heli-Access-Step, Long LH



Start Date: 23/10/2009

Required Date: 18/11/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3067-1RevA  End Plate		Manufactured	No			110	Each	68.0000	5.0000		<u>2009.11.08</u>	

Warehouse
Location
Main Warehouse
ST

Loc Qty

Loc Code

D3272-1RevB

Manufactured No



Step

MS21042L5

Purchased No



Nut

110

68

68

Each

0.0000

5.0000



5

2009.11.08 853148

110

Each

1,077.000

10.0000



9/11/17 5x SF

Warehouse
Location

Main Warehouse
ST

Loc Qty

Loc Code

1077

110382

10

111127

4

111636

63

112314

1000

10x SF

Picklist Print

October 23, 2009 9:58:03 AM

Work Order ID: 53150

Parent Item: D350-591-311RevB

Parent Item Name: Heli-Access-Step, Long LH


Start Date: 23/10/2009

Required Date: 18/11/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20600-AD4W4		Purchased	No			180	Each	2,495.000	80.0000			
<div>  </div>												
Rivets												

11-09-11

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2495	
110731	215	
111359	46	
111477	74	
112314	1960	
112385	200	

80

AN3-35A

Purchased

No

260

Each

441.0000

10.0000



Bolt

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	441	
106993	12	
110467	1	
112314	428	

all 17 50 50

10x50

Picklist Print

Page 4

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Work Order ID: 53150



Parent Item: D350-591-311RevB



Parent Item Name: Heli-Access-Step, Long LH


Start Date: 23/10/2009

Required Date: 18/11/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-13A  Bolt		Purchased	No			260	Each	308.0000	40.0000		9/11/17	SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	308	
107321	1	
107534	5	
107959	23	
109285	37	
110552	66	
110865	3	
111477	9	
111925	7	
112314	157	
17406	0	
51764	0	

M113149

28x
12x SP

Picklist Print

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Work Order ID: 53150



Parent Item: D350-591-311RevB



Parent Item Name: Heli-Access-Step, Long LH


Start Date: 23/10/2009

Required Date: 18/11/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN5-36A  Bolt		Purchased	No			260	Each	415.0000	10.0000		9/11/17	SO

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	415	
109545	11	
110467	7	
110731	4	
112243	20	
112314	323	
112385	50	

10xSO

AN960JD10

Purchased

No

260

Each

1,897.000

4x

20.0000

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	1897	
105442	95	
109059	2	
109840	23	
110985	202	
111279	5	
111668	64	
112314	1000	
112369	506	

20xSO

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Shop Packet Print

Page 5

Picklist Print

Page 6

October 23, 2009 9:58:04 AM

Work Order ID: 53150



Parent Item: D350-591-311RevB



Parent Item Name: Heli-Access-Step, Long LH



Start Date: 23/10/2009

Required Date: 18/11/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD416		Purchased	No			260	Each	4,779.000	80.0000			
											9/11/17	SD
Washer												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	4779	
108161	521	
110523	340	
111279	101	
111916	482	
112314	3335	
16941	0	

80x50

Picklist Print

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Work Order ID: 53150

Parent Item: D350-591-311RevB

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 23/10/2009

Required Date: 18/11/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960JD516

Purchased

No

260

Each

1,595.000

20.0000

Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1595

100564

2

106167

6

107534

34

107959

43

108246

46

108672

2

109059

49

109752

22

110363

46

110523

57

111279

39

112082

68

112314

500

112794

181

112828

500

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Shop Packet Print

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Picklist Print

October 23, 2009 9:58:04 AM

Work Order ID: 53150

Parent Item: D350-591-311RevB

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 23/10/2009

Required Date: 18/11/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2230-3RevG		Manufactured	No			260	Each	225.0000	20.0000			
-------------	--	--------------	----	--	--	-----	------	----------	---------	--	--	--



S
Lug



9/11/09 SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

27

51568

27

Main Warehouse

ST176

198

51428

198

20xSP

D2618RevB1

Manufactured No



S
Bushing

260	Each	271.0000	10.0000
-----	------	----------	---------



9/11/07 5xSP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST39

271

50989

200

51189

71

10xSP

Picklist Print

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Work Order ID: 53150

Parent Item: D350-591-311RevB

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 23/10/2009

Required Date: 18/11/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Biz Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2856-400RevA Manufactured No



Abraison Strip

167.3337 3.0000



9/11/17 SP (SV)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST403

50593

B52563

167.3336842

167.333684

260

Each

68.0000

5.0000

1x 80

9x 50

17 09-11-11

D3067-1RevA



End Plate

Manufactured No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

51546

68

68

260

Each

113.0000

10.0000

5

9/11/17

(SV) SP

D3235-1RevA



Mounting Lug

Manufactured No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

45398

46745

47969

113

4

9

100

10x SP

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Shop Packet Print

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Picklist Print

October 23, 2009 9:58:04 AM

Work Order ID: 53150



Parent Item: D350-591-311RevB



Parent Item Name: Heli-Access-Step, Long LH

Start Date: 23/10/2009

Required Date: 18/11/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3278-041RevC		Manufactured	No			260	Each	83.0000	5.0000			
Support Assembly												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

73

52075

73

Main Warehouse

ST471

10

51191

10

MS21042L3

Purchased

No

260

Each

3,430.000 10.0000



Nut

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

3430

110844

32

111274

35

111668

863

112314

2000

112385

500

Picklist Print

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Work Order ID: 53150

Parent Item: D350-591-311RevB

Parent Item Name: Heli-Access-Step, Long LH



Start Date: 23/10/2009

Required Date: 18/11/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L4  Nut		Purchased	No			260	Each	6,002.000	40.0000 		9/11/17	50

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	6002	
110507	184	
111827	5809	
112314	9	
15924	0	

40x50



DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. *53150*

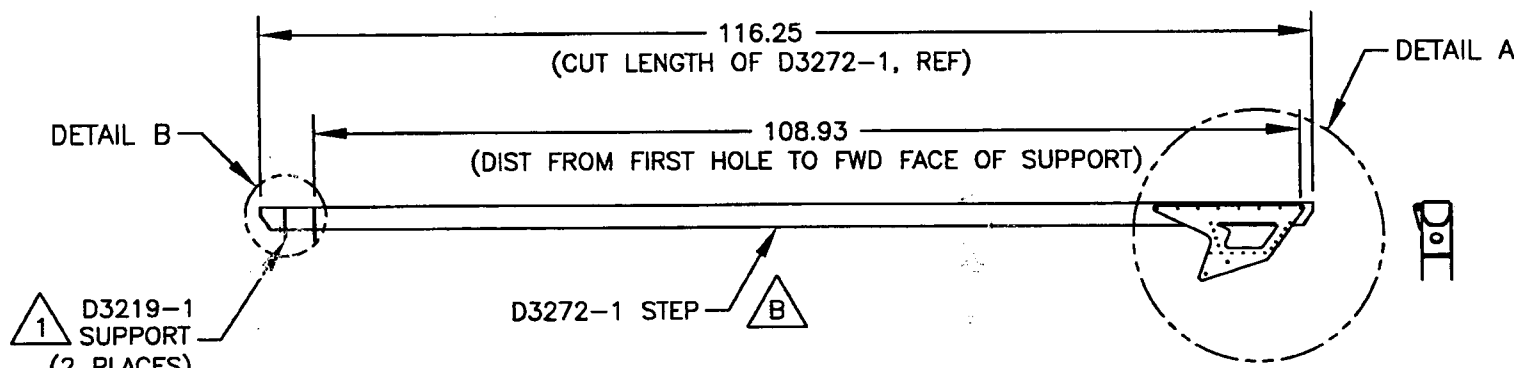
BT 09-10-23

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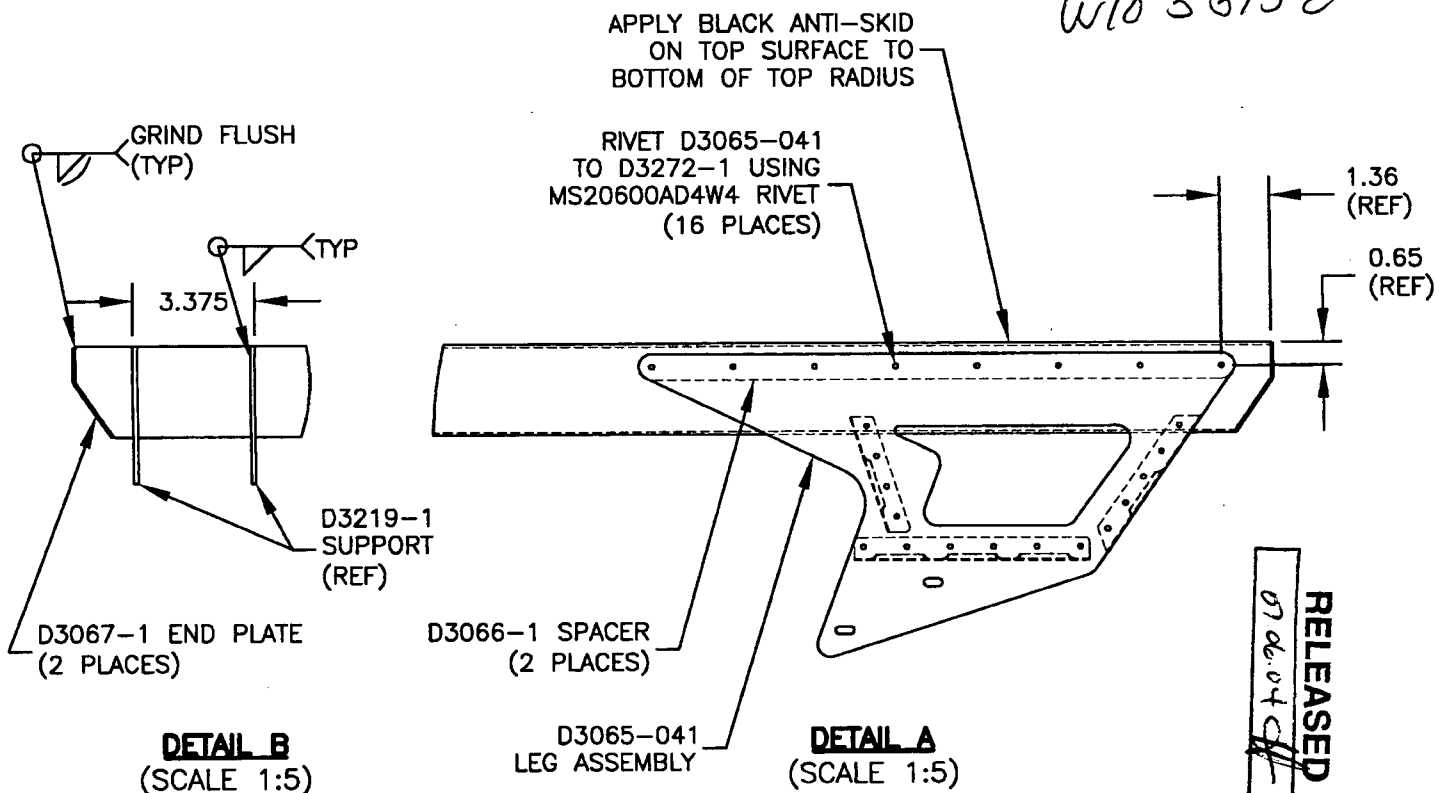


DESIGN	q	DRAWN BY	DART AEROSPACE LTD	
CHECKED	CE	APPROVED	HAMKESBURY, ONTARIO, CANADA	
DATE	07.05.18	TITLE	D3272	REV. B
			STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
				SCALE 1:20



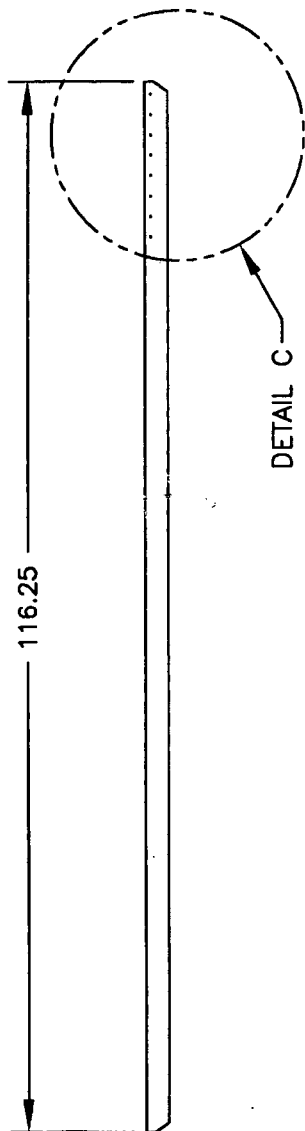
D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

w/o 53150





DESIGN <i>qp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

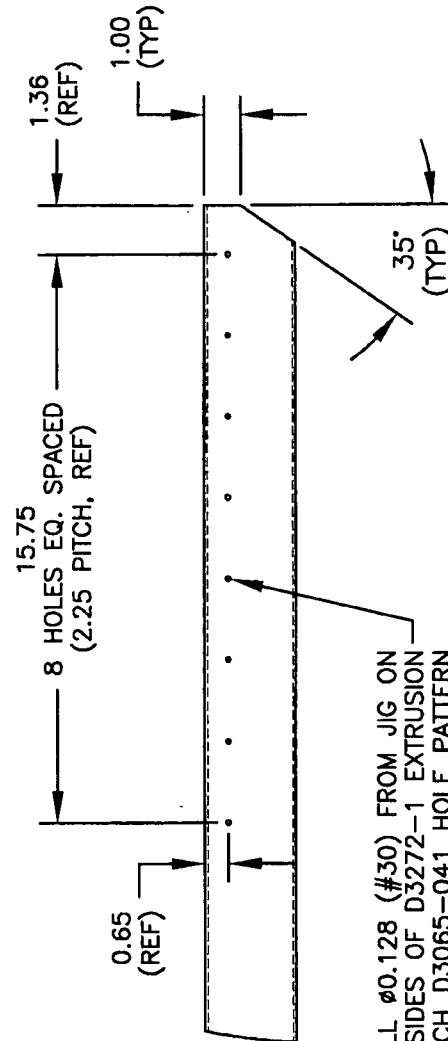


DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)

w/b 5815-d



DETAIL C
(SCALE 1:5)

RELEASED

07.06.04 *[Signature]*

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